

Date: Wednesday, 9/12/2007 12:17:06 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 34646	
Estimate Number : 12034	
P.O. Number : <i>N/A</i>	Part Number : D33555
This Issue : 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3355 REV.B
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 26943	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/21/2007
Checked & Approved By : <i>[Signature]</i> 07.09.12	Qty: <i>4</i> Um: Each
Comment : est rev A 06.01.19 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1018TR1250W120	Inventory
-----	-----------------	-----------



(4)

Comment: Qty.: 2.5830 f(s)/Unit Total : 20.6640 f(s)  
AISI 1018-1025 mild steel seamless round tubing  
1.250" od X 0.120" wall batch: *M17970* → *4* ✓ *Pl 07.09.19*

2.0	BAND SAW	BAND SAW
-----	----------	----------



(4)

Comment: BAND SAW  
Cut blank 28.250" long *Pl 07.09.19*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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(4)

Comment: CONVENTIONAL MILLING MACHINE  
1- Drill & c'sink as per dwg D3355  
2-Deburr as per dwg D3355 *Pl 07.09.19*

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP *En 07/09/19* (X) *4*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_ *Pl 07/09/19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 01/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:17:06 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 34646

Part Number: D33555

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

20768/19

Job Completion



u 0709.19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

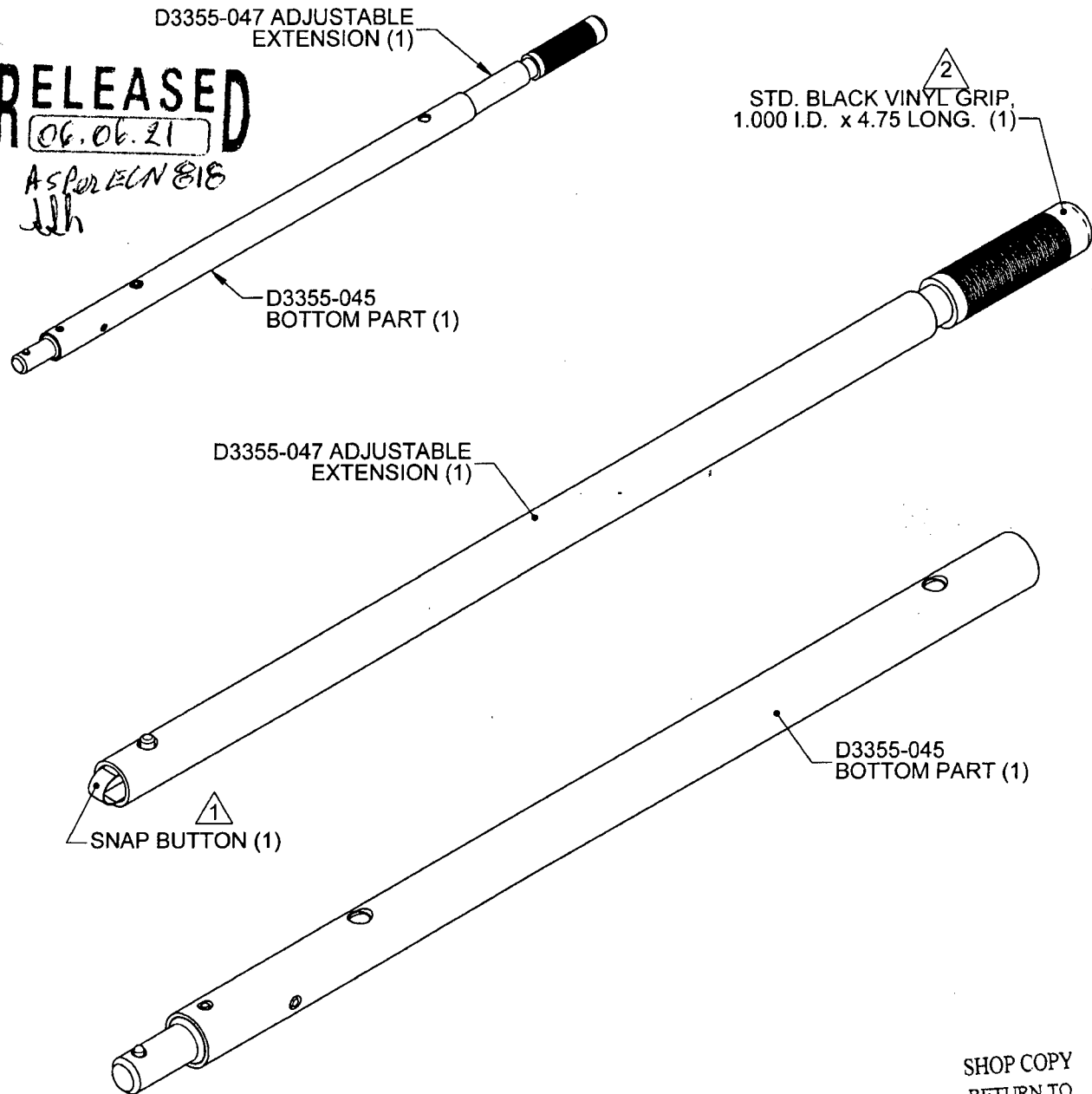
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3355</b>	REV. B SHEET 1 OF 6
DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

**RELEASED**  
**06.06.21***AS PER ECN 818*  
*[Signature]***D3355-041 HANDLE ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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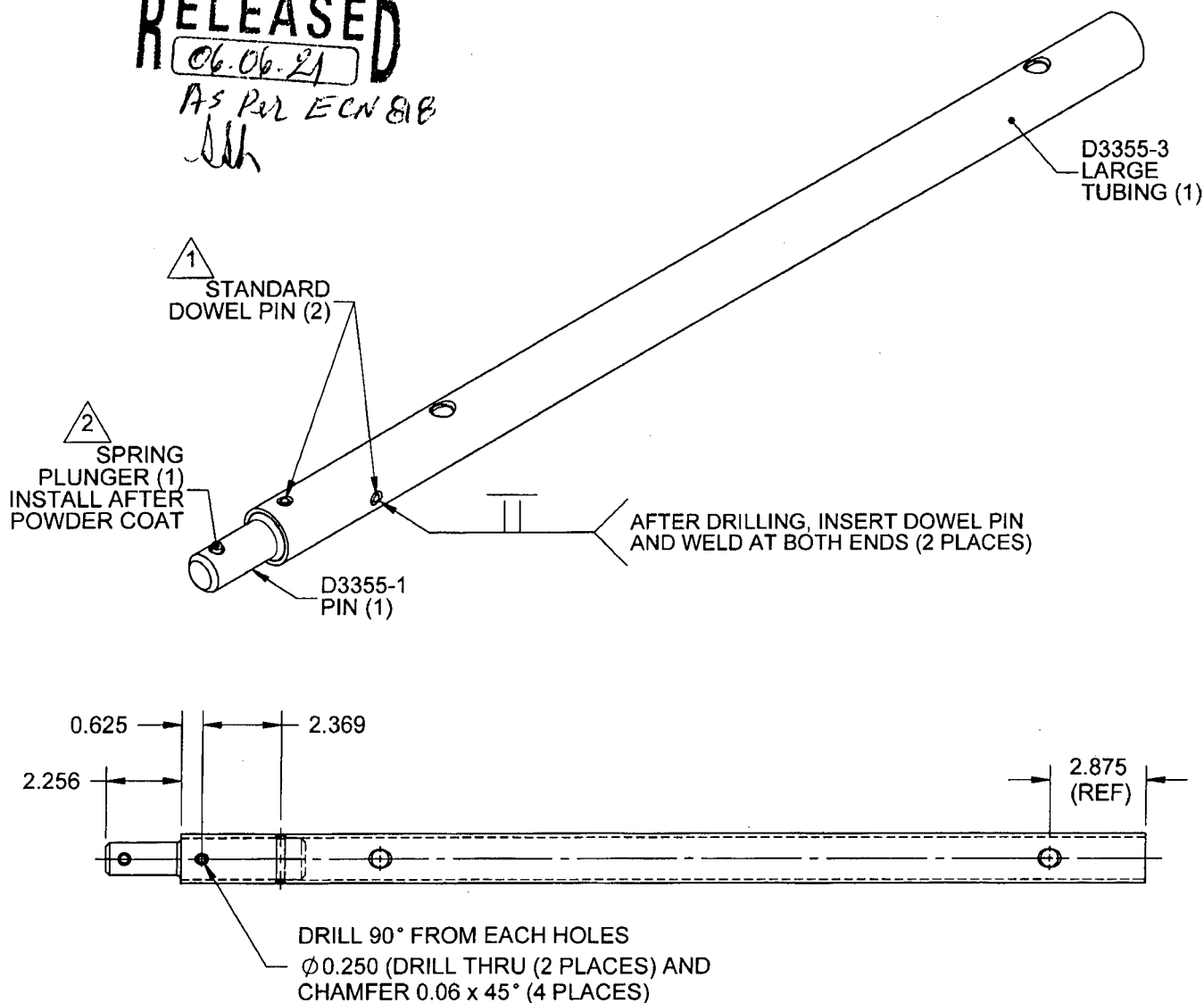
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>	SCALE 1:5	

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**06.06.21**

AS PER ECN 818

*[Signature]***D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø 0.250 X 1.50 LONG  
POSSIBLE SUPPLIER: SPAENAUER, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N 7180
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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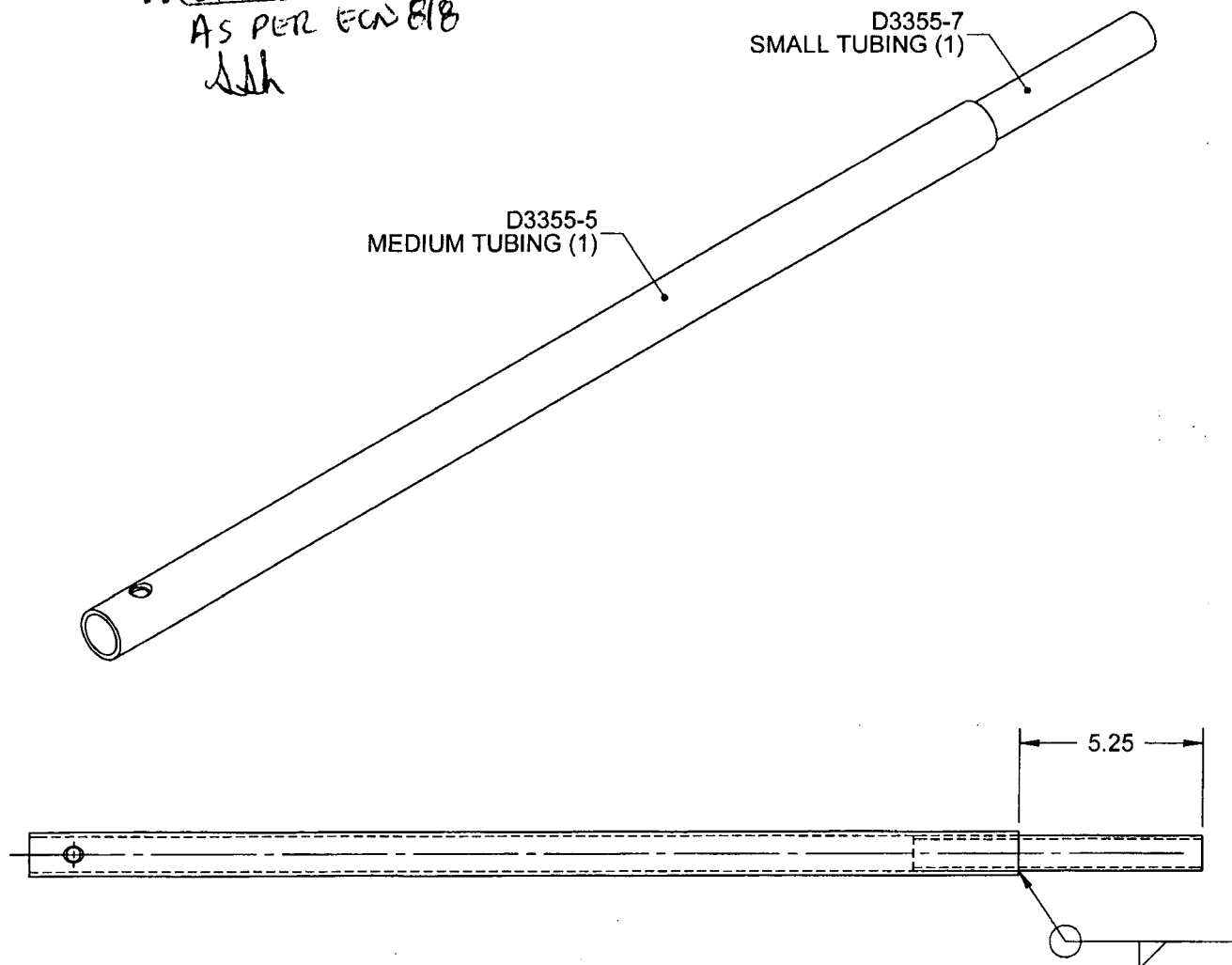
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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06.06.21

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*[Signature]*



**D3355-047 ADJUSTABLE EXTENSION**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

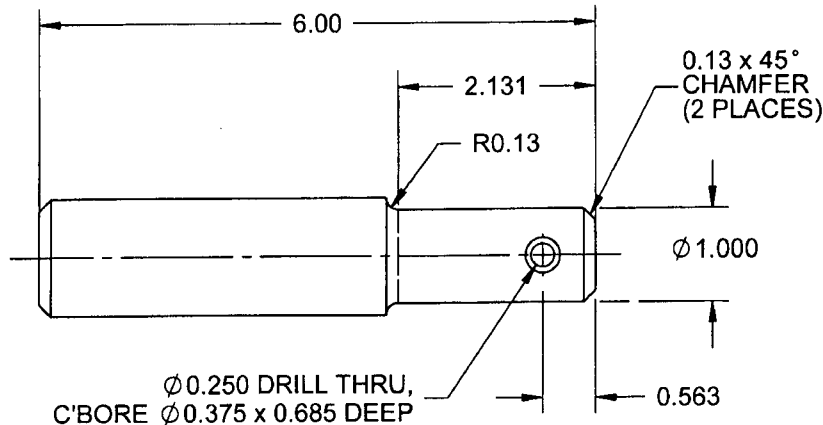
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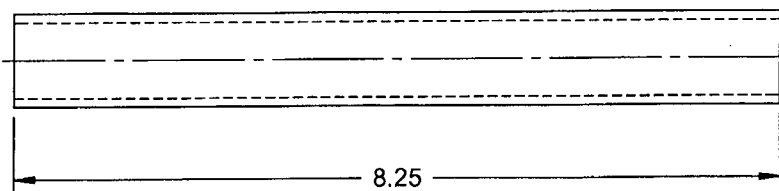
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:2

**RELEASED**  
*06.06.21*  
*AS PER ECN 818***D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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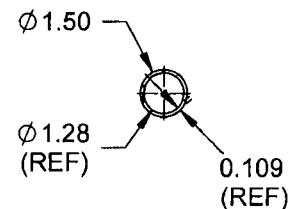
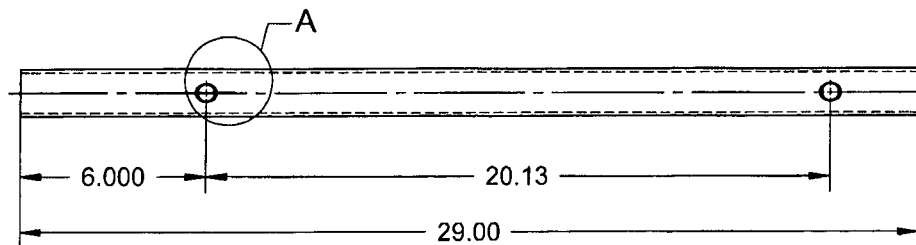
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>	SCALE 1:6	

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)

**DETAIL A**  
**SCALE 1 : 2**



### **D3355-3 LARGE TUBING**

#### **NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

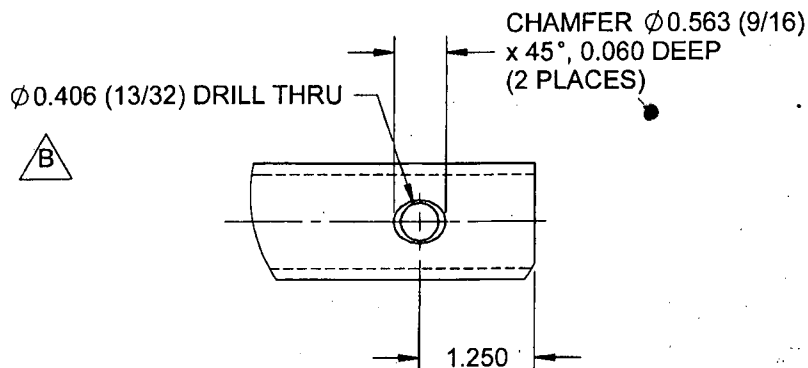
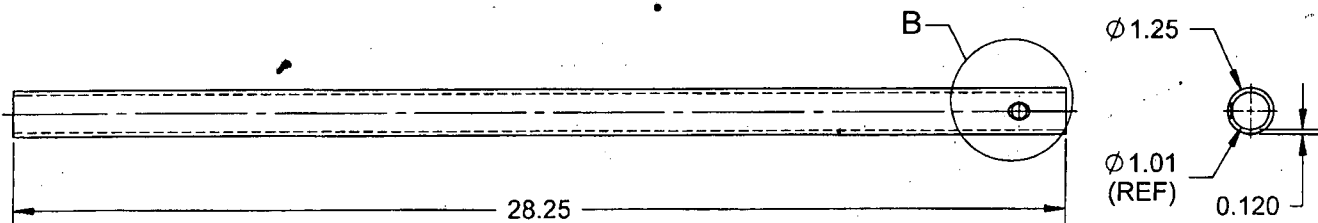
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SCALE 1 : 2**D3355-5 MEDIUM TUBING****NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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